

Date: Monday, 01/06/2009 10:31:43 AM
 User: Melanie Fauteux

Process Sheet










Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ANGLE
Job Number	: 48301 - 2		
Estimate Number	: 13959		
P.O. Number	:	Part Number	: D38971
This Issue	: 01/06/2009 S.O. No. :	Drawing Number	: D3897 PREL
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : SMALL /MED FAB	Drawing Revision	: PREL
Previous Run	:	Material	:
Written By	:	Due Date	: 01/06/2009
Checked & Approved By	: <u>mf 09-01-06</u>	Qty:	<u>8-7</u> Um: Each
Comment	: Est Rev:A 09-06-01 new issue EC verified by:DD		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S050	6061-T6 .050 Sheet
		
	Comment: Qty.: 0.2541 sf(s)/Unit Total: 1.5246 sf(s) M6061-T6 sheet 0.050" batch: <u>110791</u> <u>AB 9-6-1</u>	
2.0	WATER JET	FLOW WATER JET
		
	Comment: FLOW WATER JET 1-Cut as per Dwg Dwg Rev: <u>plf</u> Prog Rev: <u>Lim</u> <u>AB 9-6-6</u> 2- Deburr if necessary <u>AB 9-6-1</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>AB 9-6-1</u>	
4.0	QC8	SECOND CHECK
		
	Comment: SECOND CHECK <u>AB 09/06/07</u> ENGINEERING APPROVAL	
5.0	BRAKE NC	NC BRAKE
		
	Comment: NC BRAKE Bend as per Dwg <u>SB 09/06/07</u>	

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Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MD

09/06/02

(V7)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/06/02

(7)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING APPROVAL

09.06.03 (7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker, then Stock

Location: 13513

Helix

(7)

500

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/17

Job Completion



MF 09-06-16

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

09/06/12

W

09/04/12

DART AEROSPACE LTD		Work Order: 48301
Description: ANGLE		Part Number: D3897-1
Inspection Dwg: D3897-1	Rev: PRE L	Page 1 of 1

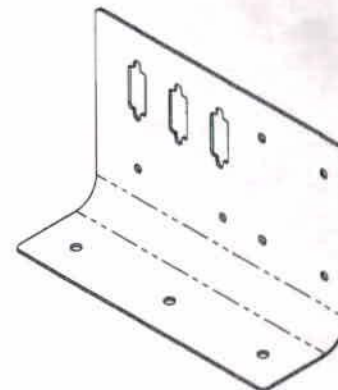
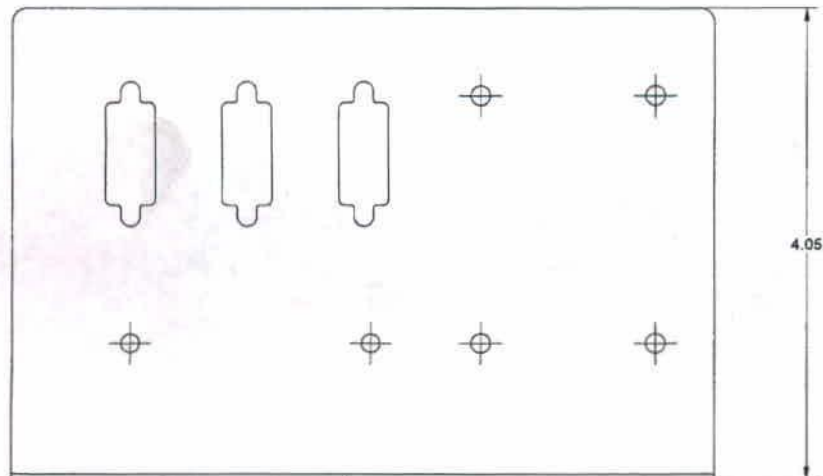
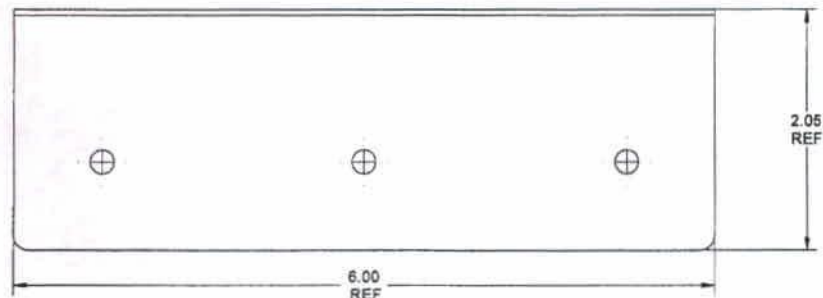
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .159	+ .005 - .001	.161	X			
Ø .264	+ .005 - .001	.266	X			
.50	± .030	.500	X			
1.500	± .010	1.499	X			
3.00	± .030	3.003	X			
4.00	± .030	4.002	X			
5.00	± .030	5.001	X			
6.00	± .030	6.001	X			
.75	± .030	.750	X			
2.88	± .030	2.870	X			
3.41	± .030					
5.07	± .030	5.074	X			
5.82	± .030	5.833	X			
.75	± .030	.751	X			
3.00	± .030	3.005	X			
5.25	± .030	5.257	X			
2.060	± .010	2.061	X			
.71	± .030	.710	X			
1.239	± .010	1.244	X			
.425	± .010	.426	X			
.880	± .010	.889	X			
.050	± .010	.046	X			

Measured by: DB	Audited by: [Signature]	Prototype Approval: N/A
Date: 9-6-1	Date: 09.06.03	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



PRELIMINARY ISSUE
March 03

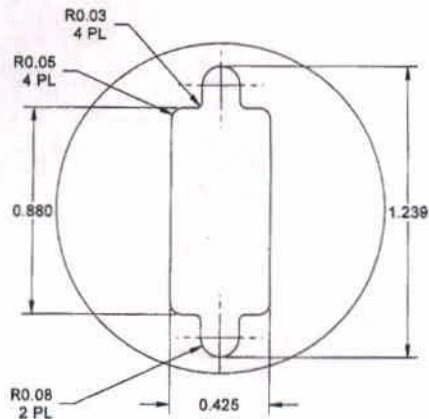
D3897-1 ANGLE
 MADE FROM D3897-1F

Wb 48301

NOTES:

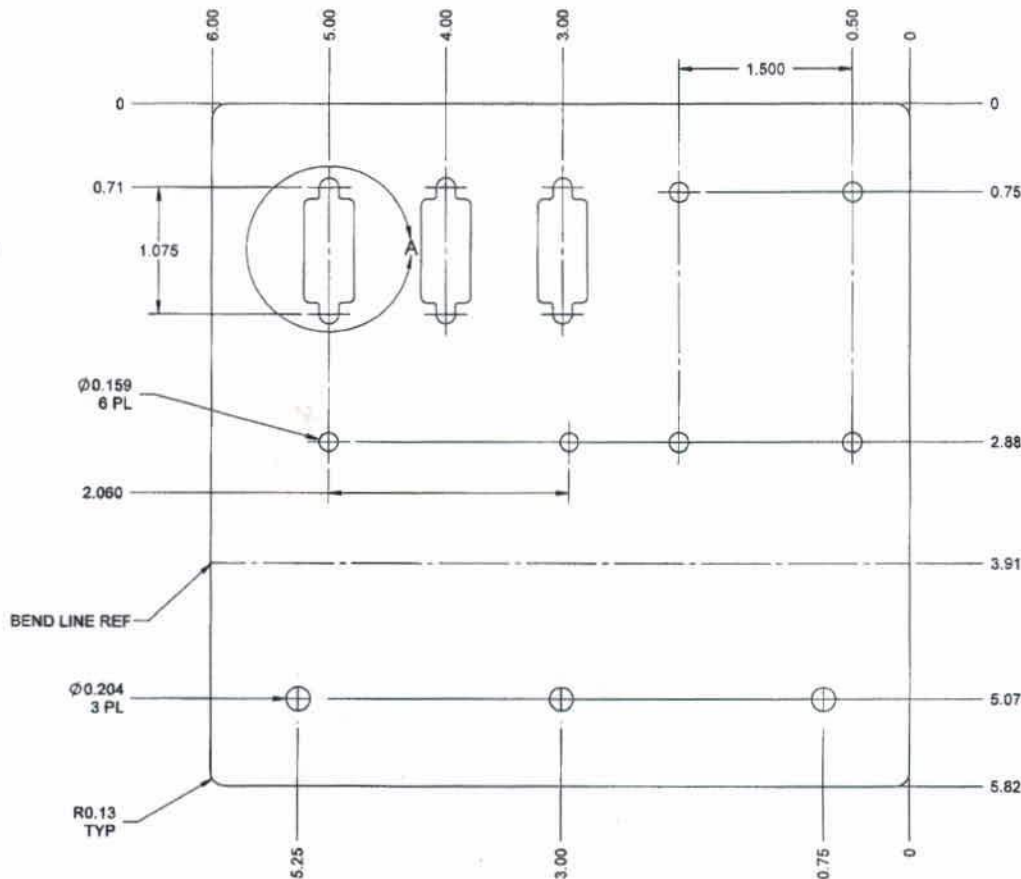
- 1) MATERIAL: MADE FROM D3897-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3897-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

A	NEW ISSUE		BY	09.03.30
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	AIS	DRAWING NO.		REV. A
MFG. APPR.		D3897		SHEET 1 OF 2
APPROVED		TITLE		SCALE
DE APPR.		ANGLE		NTS
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DETAIL A D6
TYP
SCALE 2X

PRELIMINARY ISSUE



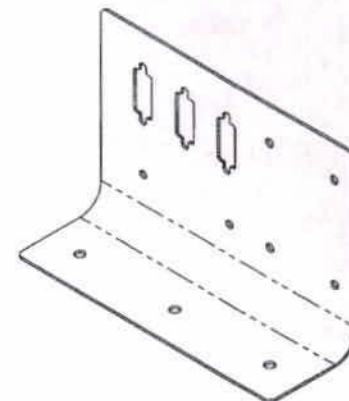
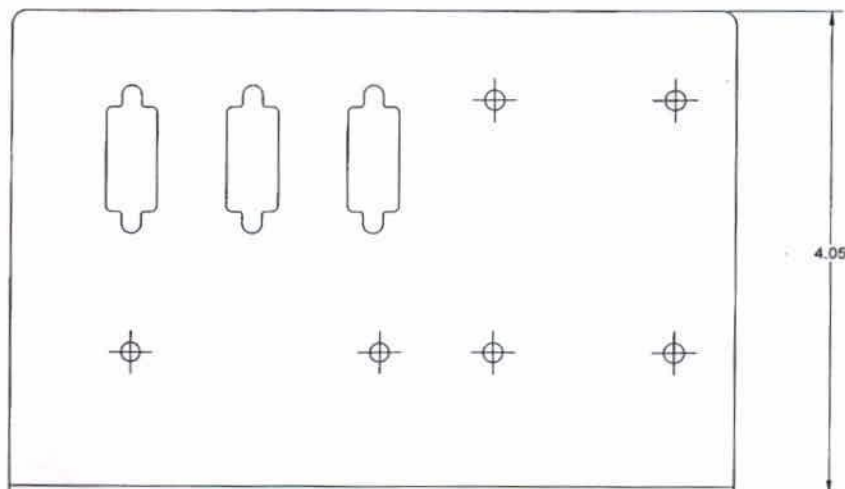
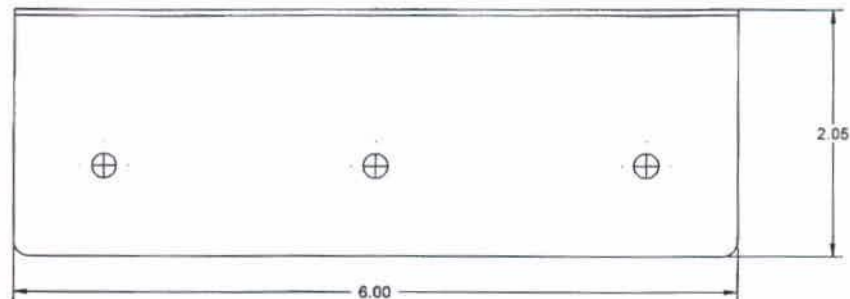
D3897-1F ANGLE FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

Wlo 48301

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. A
MFG. APPR.		D3897	SHEET 2 OF 2
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D3897-1 ANGLE
MADE FROM D3897-1F

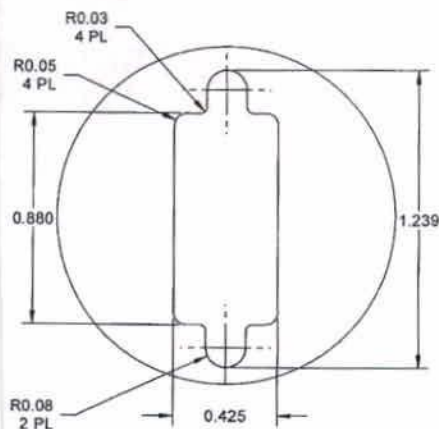
102879m

RELEASED
09/06/03

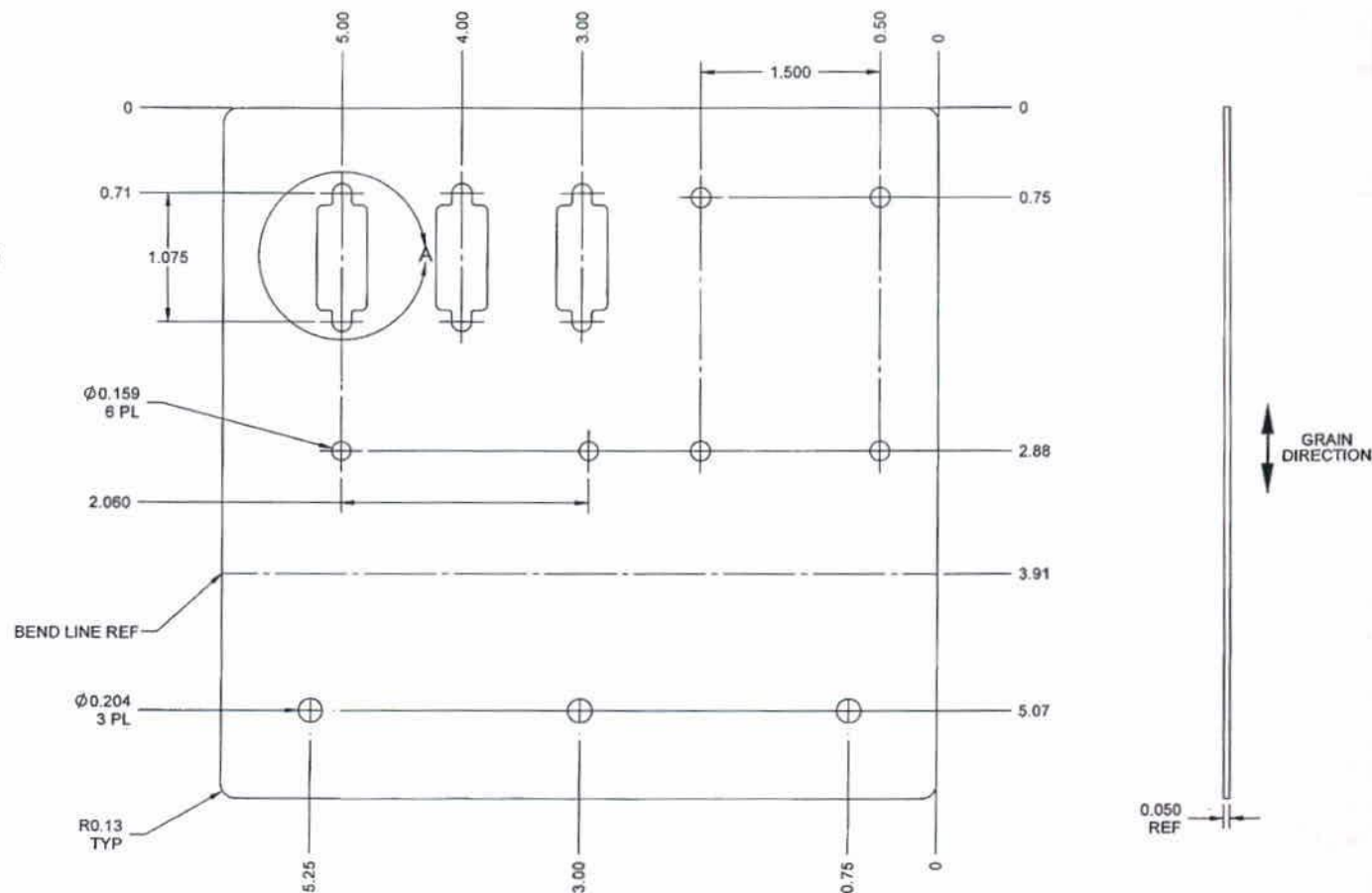
- NOTES:**
- 1) MATERIAL: MADE FROM D3897-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3897-1" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.16 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		09.03.30
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D3897	SHEET 1 OF 2
TITLE ANGLE	SCALE NTS
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DETAIL A D5
TYP
SCALE 2X



D3897-1F ANGLE FLAT PATTERN

NOTES:

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PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

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CA 06/01 NW

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